



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3883-1
Job Sheet 187259



Part No: D3883-1

Job Qty: 10 ea

Part Name: Saddle, Outboard LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/29/18

Job Tracking No:

Due Date: 1/31/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV D IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/31/19	0.00	0.00	Start Up Machining-2		SBZ 19/01/15
100	CNC Vertical Machining	10 pcs		1/31/19	0.86	20.83	HAAS1-5		SBZ 19/01/15
105	Mill Conv	10 pcs		1/31/19	0.00	20.66	Conv Mill 1		SBZ 19/01/16
110	QC	10 pcs		1/31/19	0.00	0.00	QC2 Machining-2		SBZ 19/01/16
120	QC	10 pcs		1/31/19	0.00	0.00	QC8 Machining-2		SBZ 19/01/18
130	HandFinish	10 pcs		1/31/19	0.00	0.73	HandFinish1		DR 19/01/18
140	Powdercoat	10 pcs		1/31/19	0.00	0.34	Powdercoat1		DR 19-01-22
150	QC	10 pcs		1/31/19	0.00	0.00	QC3		38
160	Packaging	10 pcs		1/31/19	0.00	0.00	Packaging3-2	5401	JAN 23 2019
170	QC21-SA	10 Ea		1/31/19	0.00	0.00	QC21		21 JAN 24 2019

Part Op 100 - Program Batch No. 5144800 Machine Step No 1 per Folio FA815 and inspect per attached Dimension Sheets 3-
Descriptions: Machine Step No 3 per Folio FA815 and inspect per Dimension Sheets MILL AS PER DWG AND FOLIO FA815

105 - MILL KEYWAY AS PER DWG

140 - ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED
ON DWG (SEE NOTE 2)*** **DO NOT MASK INSIDE FLANGE SURFACE***

M135947. START: 11:00 QTY: 300 FINISH: 11:30.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-015	Saddle Billet	10 Ea (1 ea)	90-Start up Operation	7x 511639 3x 5133664

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-015	10	7	0

Part Specifications

Specifications could not be found.

Plex 11/29/18 11:09 AM dart.white.jesse

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Lab	DEPARTMENT/PROCESS Part: D3883-1 Job No: 187259 Serial No/Batch: S144800 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 01/15/19 Container No: S144800 DART AEROSPACE Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com	
Date : _____	Sequence #: _____	QTY Affected: _____	
Description Work Order Deviation: _____			
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Presservation Material Product Improvement Process Improvement Human Factors ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐			FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
Other/Details: _____			

DART AEROSPACE LTD		Work Order: 187259
Description: Saddle, Outboard, LH		Part Number: D3883-1
Inspection Dwg: D3883	Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.645	0.644	0.646	0.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.257	0.257	0.257	0.257		
F	0.605	0.625		0.614	0.614	0.614	0.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.165		0.148	0.149	0.150	0.150		
K	0.240	0.260		0.245	0.248	0.248	0.249		
L	0.115	0.135		0.125	0.126	0.126	0.126		
M	0.140	0.165		0.150	0.148	0.148	0.148		
N	0.720	0.780		0.775	0.778	0.780	0.780		
O	0.240	0.260		0.251	0.250	0.250	0.251		
P	0.110	0.140		0.137	0.138	0.138	0.138		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	2.825	2.885		2.856	2.856	2.856	2.856		
S	0.316	0.321		0.316	0.316	0.316	0.316		
T	0.990	1.010		0.998	0.998	0.998	0.998		
U	1.745	1.755		1.750	1.75	1.750	1.750		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		0.500	0.500	0.499	0.500		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		0.313	0.313	0.313	0.313		
AB	0.020	0.040		0.030	0.030	0.028	0.030		
AC	0.760	0.765		0.760	0.760	0.760	0.760		
AD	0.215	0.220		0.219	0.219	0.219	0.219		
AE	1.265	1.285		1.265	1.265	1.265	1.265		
AF									
Accept/Reject									

Measured by: DAS	Audited by: <i>angel</i>
Date: 57 19/01/16	Date: 19/01/18

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 187259
Description: Saddle, Outboard, LH		Part Number: D3883-1
Inspection Dwg: D3883	Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	51	62	73	84	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.646	0.646	0.646	0.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.257	0.257	0.257	0.257		
F	0.605	0.625		0.615	0.615	0.615	0.614		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.25		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.165		0.148	0.150	0.149	0.148		
K	0.240	0.260		0.247	0.249	0.247	0.247		
L	0.115	0.135		0.126	0.126	0.125	0.126		
M	0.140	0.165		0.148	0.147	0.147	0.148		
N	0.720	0.780		0.778	0.778	0.780	0.780		
O	0.240	0.260		0.251	0.249	0.250	0.250		
P	0.110	0.140		0.138	0.138	0.137	0.135		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	2.825	2.885		2.858	2.856	2.856	2.858		
S	0.316	0.321		0.316	0.316	0.316	0.316		
T	0.990	1.010		0.999	0.999	1.000	0.999		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	5.999	5.999	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		0.498	0.502	0.501	0.500		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		0.313	0.313	0.313	0.313		
AB	0.020	0.040		0.030	0.028	0.028	0.034		
AC	0.760	0.765		0.760	0.760	0.760	0.760		
AD	0.215	0.220		0.219	0.219	0.219	0.219		
AE	1.265	1.285		1.265	1.265	1.265	1.265		
AF									
Accept/Reject									

Measured by:	DAS
Date:	9-89 19/01/16

Audited by:	mm
Date:	19/01/18

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
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DART AEROSPACE LTD		Work Order: 187.259
Description: Saddle, Outboard, LH		Part Number: D3883-1
Inspection Dwg: D3883	Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9 1	10 2	3	4	By	Date
A	2.870	2.880		2,875	2,875				
B	1.433	1.443		1,438	1,438				
C	0.638	0.658		647	646				
D	3.895	3.905		3,900	3,900				
E	0.257	0.262		257	257				
F	0.605	0.625		615	615				
G	1.120	1.130		1,125	1,125				
H	2.245	2.255		2,250	2,250				
I	2.000	2.020		2,000	2,000				
J	0.140	0.165		146	148				
K	0.240	0.260		246	248				
L	0.115	0.135		127	126				
M	0.140	0.165		148	149				
N	0.720	0.780		780	780				
O	0.240	0.260		249	249				
P	0.110	0.140		138	136				
Q	0.178	0.198		188	188				
R	2.825	2.885		2,856	2,856				
S	0.316	0.321		316	316				
T	0.990	1.010		998	1,000				
U	1.745	1.755		1,750	1,750				
V	5.990	6.010		6,000	6,000				
W	1.245	1.255		1,250	1,250				
X	0.490	0.510		502	501				
Y	1.220	1.280		1,250	1,250				
Z	2.495	2.505		2,500	2,500				
AA	0.313	0.318		313	313				
AB	0.020	0.040		035	035				
AC	0.760	0.765		760	760				
AD	0.215	0.220		219	219				
AE	1.265	1.285		1,265	1,265				
AF									
Accept/Reject									

Measured by: DAS
Date: 57 19/01/16

Audited by: <i>[Signature]</i>
Date: 19/01/18

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
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